

**Work Order ID 52302**

Page 1

Tuesday, September 22, 2009 2:32:33 PM

Item ID: D2884

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle Spacer

Start Date: 9/23/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: *BT M&M*

Date: 09-9-22

Tooling:

Date:

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D2884	Rev B	

100



FLOW WATER JET

Waterjet

Memo

0.00

*KB 9-10-17*

FLOW CNC Waterjet

1-Cut as per Dwg D2884  Dwg Rev: *B*  Prog Rev: *B*  2-  
Tumble ,Deburr if necessary*Deburr m.r. 09/10/19**(56)*

110



QC2- Inspect parts off machine FAI/FAIB

0.00

*KB 9-10-17*

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

*control*

QC

0.00

Quality Control

*→ 8 09/10/19**(456)**✓*

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Customer:

**Reference:**

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

130



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

BL 09-10-19

0.00

Hand Finishing

140



QC3- Inspect Part Finish

QC

Quality Control

0.00

MD 09/10/19

0.00

x56

150

Identify as per dwg & Stock Location: 52

0.00

Packaging

Memo

0.00

Packaging

9/10/19

56et Sf

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Accept



Setup Start



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Stop



Item Name: Saddle Spacer

Start Date: 9/23/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memos

0.00

09/10/20 AF

MF

09-10-20

# Picklist Print

Page 1

Tuesday, September 22, 2009 2:32:33 PM

Work Order ID: 52302



Parent Item: D2884RevB



Parent Item Name: Saddle Spacer

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased		No		100	sf	110.7094	2.6568	3.7195		BS-10-17

6061-T6 .080 Sheet

Warehouse      Loc Qty      Loc Code

Location

Main Warehouse

MAT	110.7094	
107904	0.02	
110254	2.5	
110630	38.0926	
112040	0.0437	
112141	33	
112512	37.0531	112512

50

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	52302
<b>Description:</b> Saddle Spacer	<b>Part Number:</b>	D2884
<b>Inspection Dwg:</b> D2884 <b>Rev:</b> B		<b>Page 1 of 1</b>

# FIRST ARTICLE INSPECTION CHECKLIST

## **X** First Article Prototype

Measured by:	HB	Audited by:	S	Prototype Approval:	N/A
Date:	9-10-17	Date:	09/10/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.12.07	New Issue	KJ/JLM	E

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SUBJECT

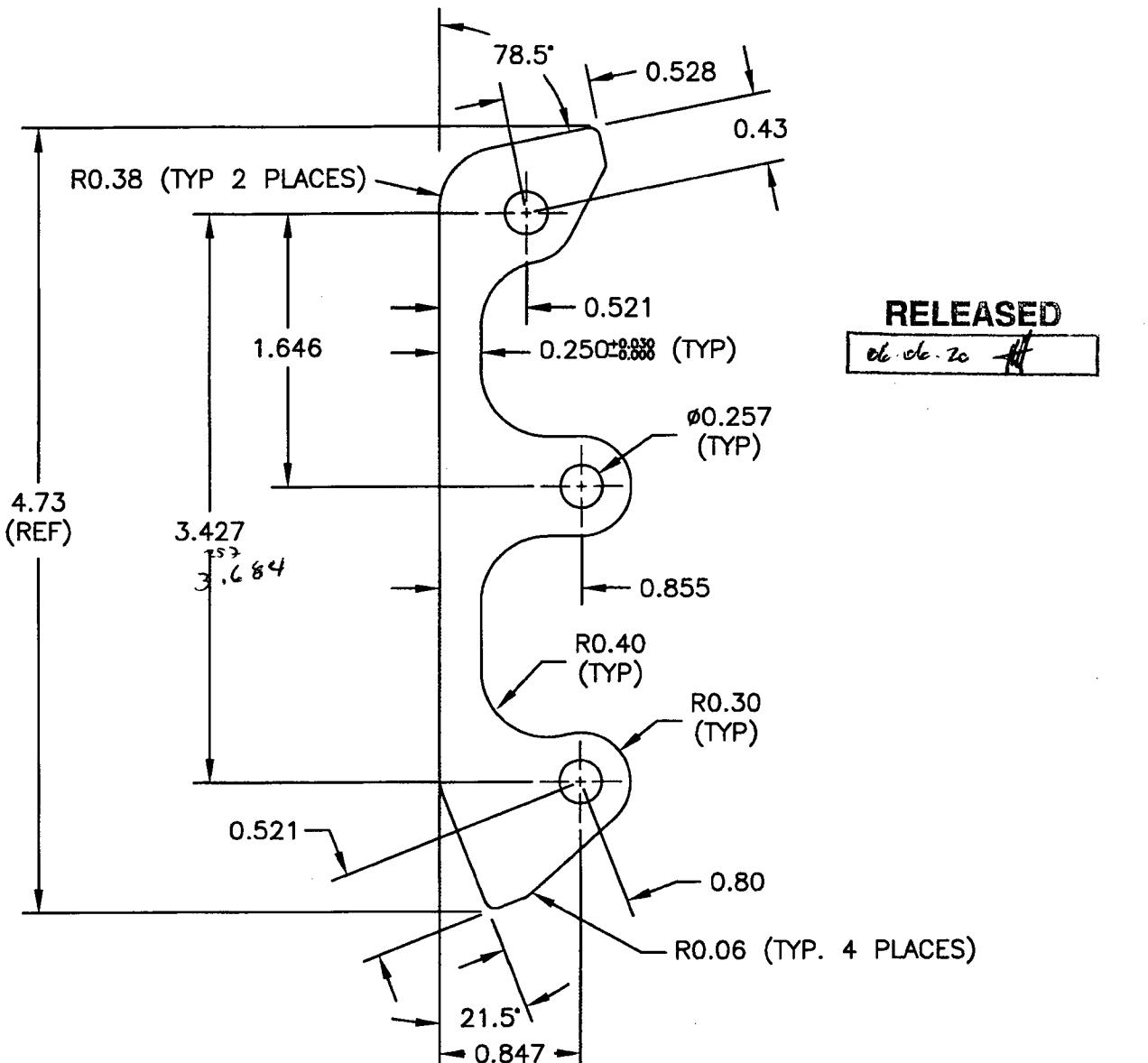
**DART**

WITH ATTACHED

WORK ORDER

NO. 52302

DESIGN	CP	DRAWN BY	CB	DART AEROSPACE LTD	
CHECKED	PH	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. B
DATE	06.05.29			D2884	SHEET 1 OF 1
				TITLE	SCALE
				SADDLE SPACER	1:1
A	99.04.01	NEW ISSUE			
B	06.05.29	ADD 6061-T6 MATERIAL			



NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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